



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.1812
Job Sheet 181360

DAS
21
9-83



Part No: 647.1812

Job Qty: 50 ea

Part Name: Shim



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/26/18

Job Tracking No:

Due Date: 9/10/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV N/C SHEET 3 IPP REV:A 12.10.03 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	50 Ea		9/10/18	0.00	0.00	Start Up Waterjet		21 18/08/21
110	Waterjet	50 pcs		9/10/18	0.00	2.21	Waterjet1		21 18/08/21
120	QC	50 pcs		9/10/18	0.00	0.00	QC2 Waterjet-1		21 18/08/21
130	QC	50 pcs		9/10/18	0.00	0.00	QC8-1		AUG 22 2018 38
140	Outsource	50 pcs		9/10/18	0.00	0.00	Outsource4		SEP 04 2018 38
150	Packaging	50 pcs		9/10/18	0.00	0.00	Packaging2		SEP 04 2018 38
160	QC	50 pcs		9/10/18	0.00	0.00	QC5		38
170	SprayPaint	50 pcs		9/10/18	0.00	0.67	Spray Paint		9-89
180	QC	50 pcs		9/10/18	0.00	0.00	QC14		SEP 07 2018
190	Packaging	50 pcs		9/10/18	0.00	0.00	Packaging3-1		SEP 11 2018
200	QC21-SA	50 Ea		9/10/18	0.00	0.00	QC21		SEP 11 2018

Part Op 110 - 1-Cut as per Dwg Dwg Rev: n/c Prog Rev: n/c 2-Deburr if necessary

Descriptions: 140 - ISSUE P/O: 040820 HARD ANODIZE, COLOR BLACK AS PER DWG.(SEE NOTE 2)

170 - PRIME IAW MIL-P-23377J TYPE1 CLASS N AS PER DWG. (SEE NOTE 2) CARDINAL 4860-50 PRIMER

BATCH:

190 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.063	2024-T3 .063 Sheet	.8500 sf (.017 ea)	90-Start up Operation	5104069.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.063	1	86	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Shim	0.200Inches + 0.005 - 0.001	0.205 0.199	Diameter	
2	Shim	0.603Inches ± 0.005	0.608 0.598		
3	Shim	0.350Inches ± 0.005	0.355		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Forming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Composite ☐</td> <td style="border: none;"></td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>			Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Forming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Composite ☐		Supplier ☐																																
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Date : _____	Step #: _____	MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																	
Description Work Order 		 DART AEROSPACE Container No: S104070 Part: 647.1812 Job No: 181360 Serial No/Batch: S104070 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____ Date: 06/21/18																																																	
Root Cause <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Environment ☐</td> <td style="border: none;">No Re-verification ☐</td> <td style="border: none;">Pressure ☐</td> <td style="border: none;">Positioned Wrong ☐</td> </tr> <tr> <td style="border: none;">Design ☐</td> <td style="border: none;">Operator ☐</td> <td style="border: none;">Bending ☐</td> <td style="border: none;">Outside Dimensions ☐</td> </tr> <tr> <td style="border: none;">Doc/Data ☐</td> <td style="border: none;">Offset/Setup ☐</td> <td style="border: none;">Centre Not Concentric ☐</td> <td style="border: none;">Over/Under tolerance ☐</td> </tr> <tr> <td style="border: none;">Equip/Tooling ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;">Cracks ☐</td> <td style="border: none;">Part Incorrect ☐</td> </tr> <tr> <td style="border: none;">Handling/Pre ☐</td> <td style="border: none;">Training ☐</td> <td style="border: none;">Crimp/Kink/Ripple/Wave ☐</td> <td style="border: none;">Part Lost/Missing ☐</td> </tr> <tr> <td style="border: none;">Material ☐</td> <td style="border: none;">Use for Testing ☐</td> <td style="border: none;">Cuffs ☐</td> <td style="border: none;">Part Moved ☐</td> </tr> <tr> <td style="border: none;">Internal Transport ☐</td> <td style="border: none;">Poor Information ☐</td> <td style="border: none;">Crushing ☐</td> <td style="border: none;">Drawing ☐</td> </tr> <tr> <td style="border: none;">Tribal Knowledge ☐</td> <td style="border: none;">Rushing ☐</td> <td style="border: none;">Heat Treat ☐</td> <td style="border: none;">Finish ☐</td> </tr> <tr> <td style="border: none;">LOA ☐</td> <td style="border: none;">Product Improvement ☐</td> <td style="border: none;">Wave/Twist in Tube ☐</td> <td style="border: none;">Misread ☐</td> </tr> <tr> <td style="border: none;">Substation ☐</td> <td style="border: none;">Process Improvement ☐</td> <td style="border: none;">Marks/Chatter ☐</td> <td style="border: none;">Turning Sequence ☐</td> </tr> <tr> <td style="border: none;">Past Expiry Date ☐</td> <td style="border: none;">Manufacturing Process ☐</td> <td style="border: none;"></td> <td style="border: none;"></td> </tr> <tr> <td style="border: none;">Misidentified ☐</td> <td style="border: none;">Past Due ☐</td> <td style="border: none;">OTHER : _____</td> <td style="border: none;"></td> </tr> </table>				Environment ☐	No Re-verification ☐	Pressure ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐			Misidentified ☐	Past Due ☐	OTHER : _____	
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			0.345
4	Shim	0.700Inches $\pm$ 0.005	0.705 0.695
5	Shim	2.250Inches $\pm$ 0.005	2.255 2.245
6	Shim	3.460Inches $\pm$ 0.005	3.465 3.455
7	Shim	0.063Inches $\pm$ 0.005	0.068 0.058

Plex 7/26/18 7:29 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040820**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO040820

PO Date: 8/23/18

Due Date: 9/7/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Tsimiklis, Chrisoula

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	181296	C10-11	Manual Release Knob -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A- 8625 TYPE-2 CLASS- 2, Water sealant -Certificate of Conformity is required	Firmed	-	8/29/18	10 pcs	0 pcs	10 pcs	\$17.25/pcs	\$172.50
10 X AUG 24 2018											
Line Item Note *need this back ASAP*											
2	181360	647.1812	Shim ISSUE P/O: HARD ANODIZE, COLOR BLACK AS PER DWG.(SEE NOTE 2)	Firmed	-	9/7/18	56 pcs	0 pcs	56 pcs	\$9.10/pcs	\$509.60
56 X SEP 04 2018											
Grand Total:											\$682.10

DAS
38
9-89

Order Notes

CC

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041. quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/23/18 1:11 PM dart.tsimiklis.chrisoula

